

Work Order ID 91988

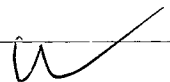
91988

Page 1

October-19-12 7:43:49 AM

Item ID: D3282-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Web (206L/407)
 Start Date: 10/19/12 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 11/02/12 Req'd Qty: 10.00 ***10*** Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3282	D

100	Skidtubes	0.00							
100	Memo	0.00							
Skidtubes	1-Cut to length as per Dwg D3282.								
Skidtubes	2- inspect for surface damage as per QSI0018								
	3- Deburr								

Handwritten: > DL 12/10/19

110	HAAS CNC VERTICAL MACHINING #1	0.00							
110	Memo	0.00							
HAAS 1	1-Machine as per Folio FA579 & Dwg D3282								
HAAS CNC vertical machine #1	2-Deburr								

Handwritten: FK 12/10/23, 2P 12-10-24, 10, 10

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120	Memo	0.00							
QC									
Quality Control									

Handwritten: FK 12/10/23, 1P 12-10-24, 10, 10

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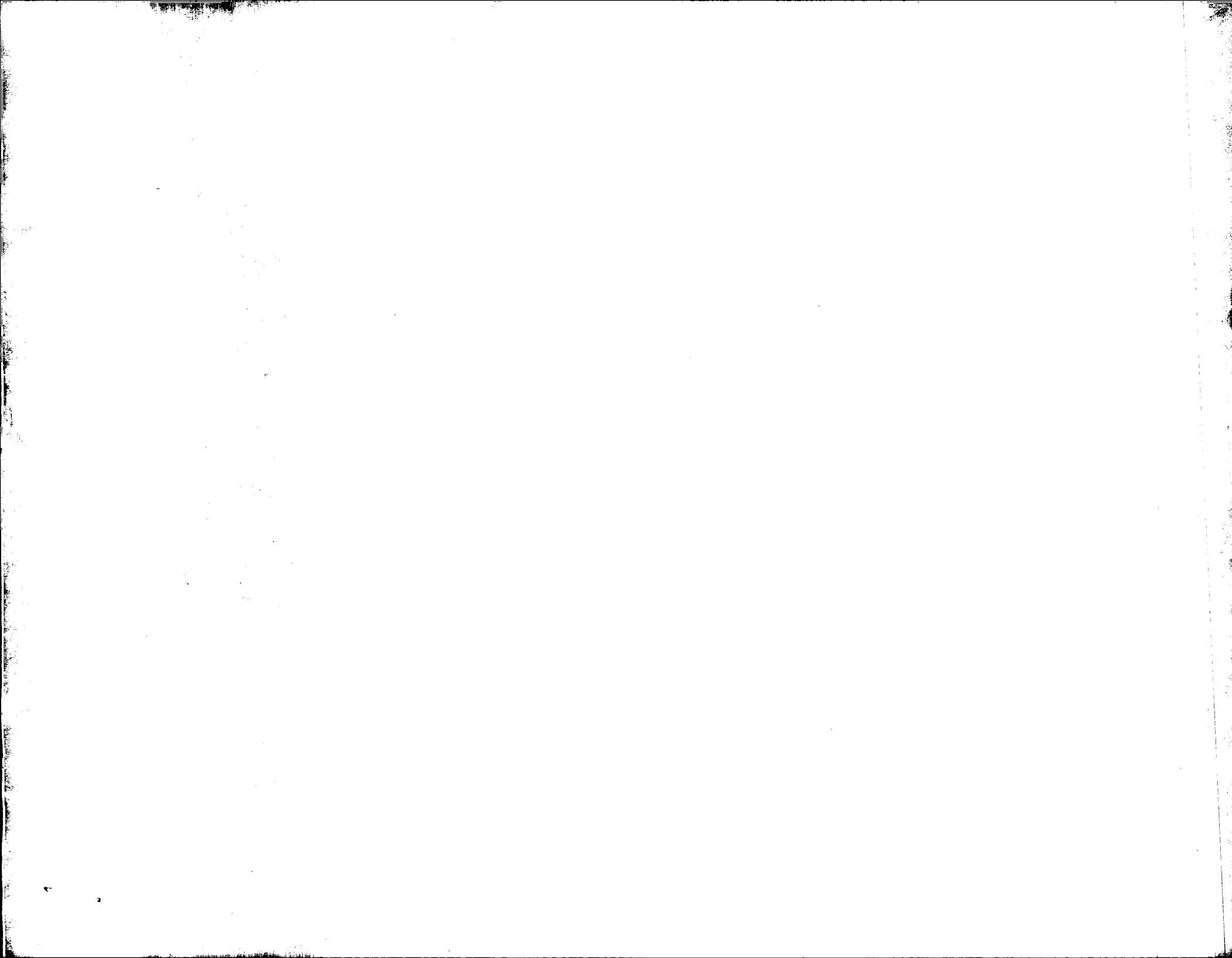
Page 2

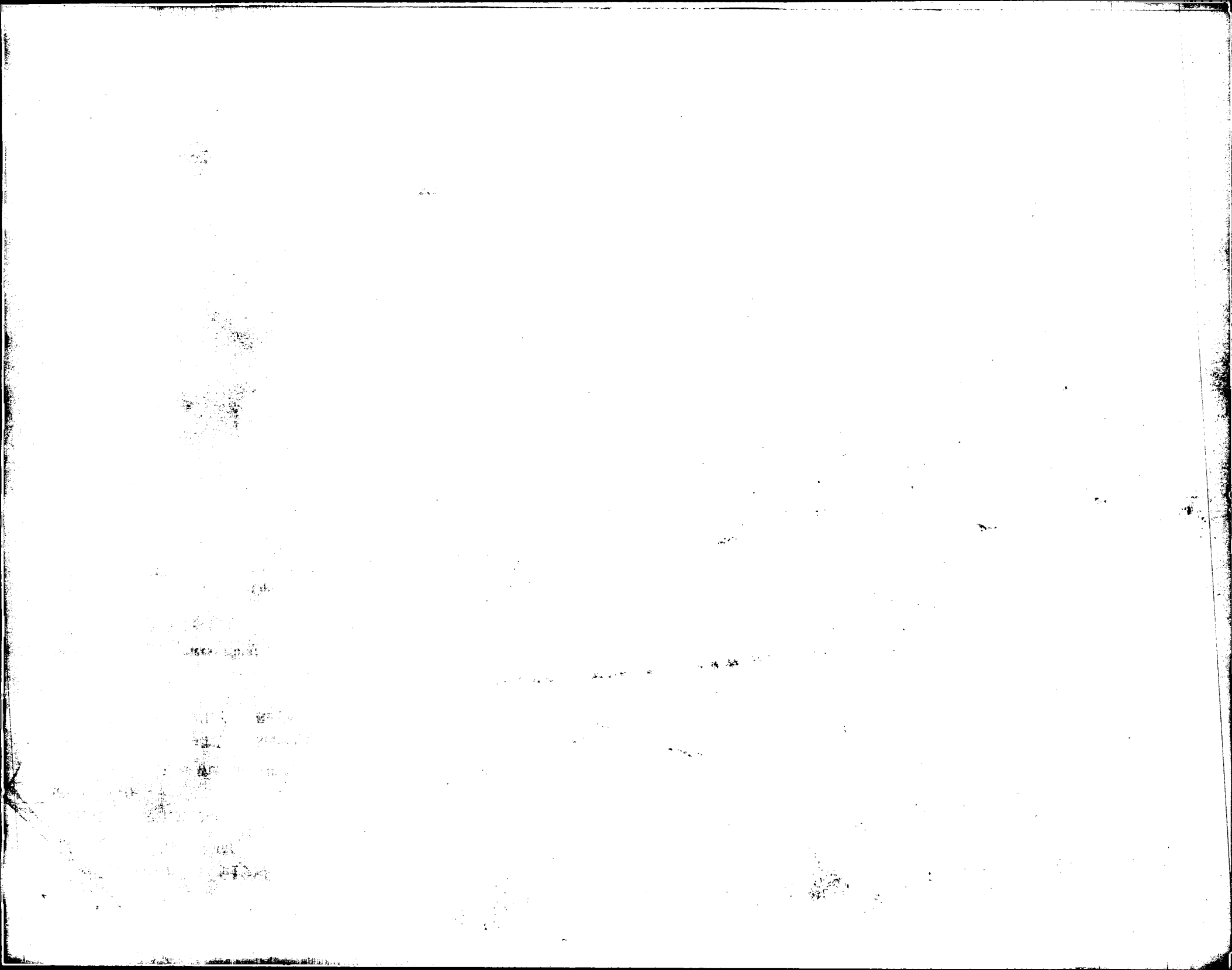
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		12/10/26		10	0		DAS 08 8-83
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	26	12-10-30	
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				10	SMD	12-10-30	





Picklist Print

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Work Order ID: 91988

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 10/19/12

Required Date: 11/02/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B05.09.23Procedure changeKJ/JLM IPP REV:C 11.09.20 remove LPS as per dwg
revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2792-130 EXTRUSION		Manufactured	No			100	Each	10.0000	1	10		DC 12/10/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT006		10							
				72839		10							
D3283-1 Doubler		Manufactured	No			160	Each	28.0000	2	20		SAD 12-10-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST176		28							
				82125		4							
				85511		24							
MS20470AD4-7 Rivet, Universal Head		Purchased	No			160	Each	1,741.0000	57	570		SAD 12-10-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				336		1300							
				122452		1300						570	
				ST139		124							
				121415		124							
				ST319		52							
				120769		52							
				ST320		265							
				116081		117							
				118614		148							

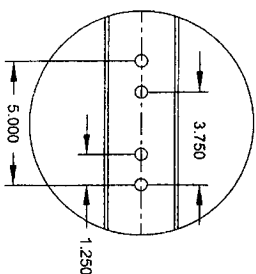
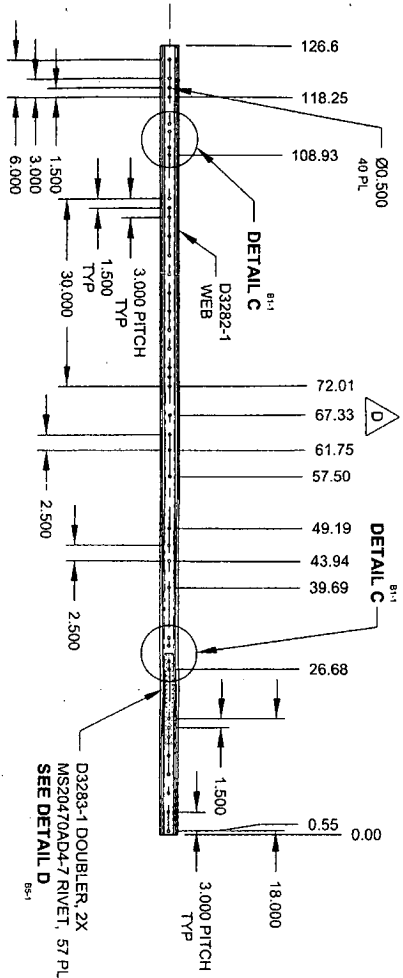
DART AEROSPACE LTD		Work Order: 91988
Description: Float Web		Part Number: D3282-041
Inspection Dwg: D3282	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.625	✓		FK-05	Tape
1.500	+/-0.010	1.500	✓		FK-04	Vern.
3.000	+/-0.010	3.000	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
30.000	+/-0.010	30.000	✓		Tape	FK-05
1.500	+/-0.010	1.500	✓		FK-04	Vern.
72.01	+/-0.030	72.01	✓		FK-05	Tape
61.75	+/-0.030	61.75	✓		"	"
57.50	+/-0.030	57.50	✓		"	"
49.19	+/-0.030	49.19	✓		"	"
43.94	+/-0.030	43.94	✓		"	"
39.69	+/-0.030	39.69	✓		"	"
26.68	+/-0.030	26.68	✓		"	"
0.55	+/-0.030	.55	✓		FK-04	Vern.
1.970	+/-0.010	1.970	✓		"	"
2.38	+/-0.030	2.375	✓		"	"
0.05	+/-0.030	.50	✓		"	"

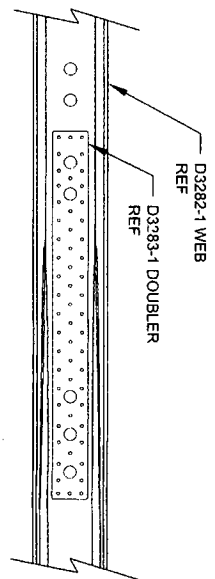
Measured by: FK.	Audited by: D.A. (DAS)	Preliminary Approval:
Date: 12/10/23	Date: 12/10/26	Date:

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	



DETAIL C

NOTE: RIVET HOLES/DOUBLER NOT SHOWN FOR CLARITY



DETAIL D

- NOTES:
- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 6) IDENTIFICATION: IDENTIFY WITH PIN "D3282-041" PER OSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 - 7) WEIGHT: 20.0 lbs
 - 8) SEE PAGE 2 FOR MACHINING DETAILS

REV.	DESCRIPTION	BY	DATE
D	ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
DESIGN	CP		
DRAWN	SC		
CHECKED	CP		
MFG. APPR.	CP		
APPROVED	CP		
DE APPR.	CP		
DATE	11.05.05		

DART AEROSPACE USA, INC

PORT HADLOCK, WA

DRAWING NO.

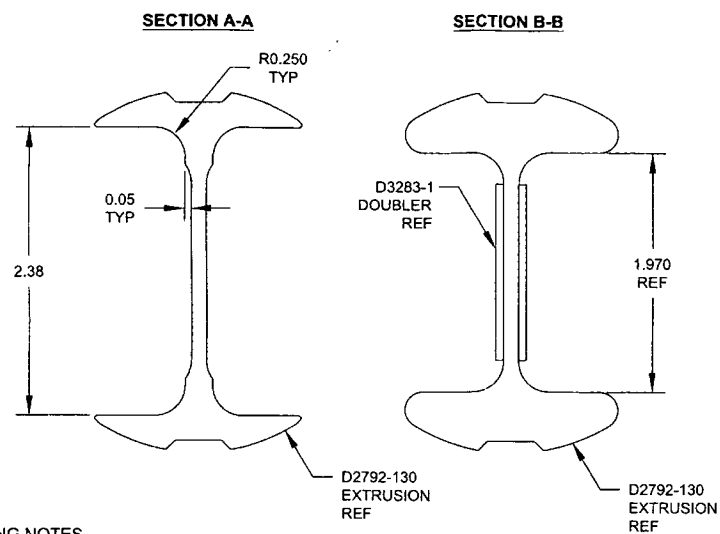
D3282

SHEET 1 OF 2

SCALE

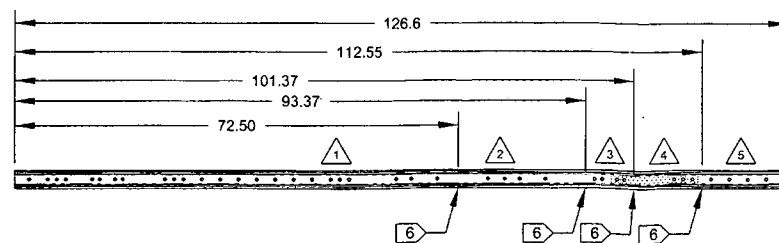
NIS

RELEASED
2011-09-21



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 ($\varnothing 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
R 2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3282	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	